



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB23005023-3
Job Sheet 200900



Part No: RB23005023-3

Part Name: Ring

Job Qty: 3 pcs *6 pcs* **DAS**



21
9-09

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/18/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 11/11/19

Type: SOLD

Description:

Note: DWG RB23005023 Rev 1 IPP Rev. A 19.09.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run		
					Hrs	Hrs	Workcenter / Supplier Lead Time	
100	SL-2500Y - 1	3 pcs		11/11/19	1.00	0.38	SL-2500Y - 1	<i>IL 19-17</i>
110	QC 2	3 pcs		11/11/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	<i>IL</i>
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	

120 QC 8	3 pcs	11/11/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	mka 9/11/18
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
130 Outsource - 12 - Black Oxide	3 pcs	11/11/19		GRO002-VC	2019-11-18
140 Packaging 2-1 - Recelve - B4B	3 pcs	11/11/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	NOV 25 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
150 QC 5	3 pcs	11/11/19	0.00 0.00	QC 6 - 9	DAS NOV 26 2019 68
				QC 6 - 68	

160 Packaging 3-1 - Stock - B4B 3 pcs	11/11/19	0.00 0.00	QC 6 - 61	
			QC 6 - 40	
			QC 6 - 81	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	DA
			Packaging 3 - 5 - B4B	20
			Packaging 3 - 6 - B4B	9-89
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	DAS
			Packaging 3 - 26 - B4B	21 NOV 26 2019
170 QC 21 - SA 3 pcs	11/11/19	0.00 0.00	QC 21 - SA - 21	9-89
			QC 21 - SA - 70	
			QC 21 - SA - 53	GA/41

Part Op 100 - 1-Machine as per folio FD 080 FOLIO REV: AA DWG REV: 1 2-Deburr 3-Apply
 Descriptions: LPS-3 to ALL steel parts

110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Issue P/O: 45129 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required

140 - (Receive & Inspect for Damage & Mat'l Certs) Certificate of Conformity is required

150 - QC6- All purchased or subcontracted products

160 - Identify as per dwg & Stock Location:

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018TR2.500W.250	M1018TR2.500W.250	.1500 ft (.05 ea)	100-SL-2500Y - 1	5187862
	MT-AS13-T-2.500W.0.250			

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-SL-2500Y - 1	M1018TR2.500W.250	0	0	0
	MT-AS13-T-2.500W.0.250			

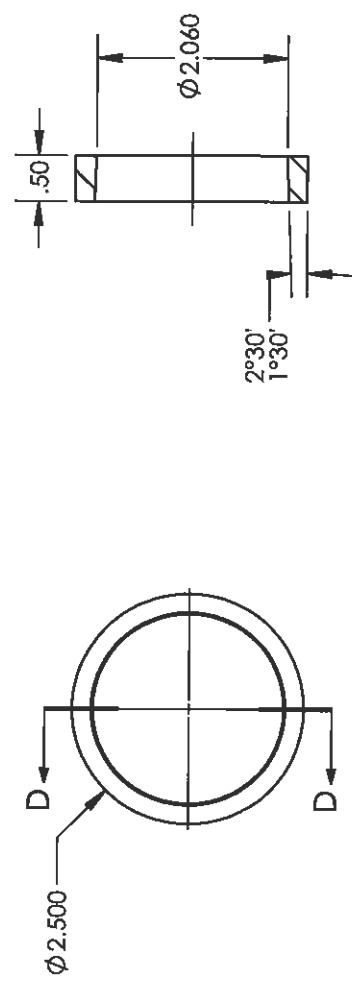
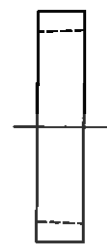
Part Specifications

Specifications could not be found.

Plex 9/18/19 2:34 PM Dart.lajeunesse.marie

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REV		ECR		REVISIONS		DESCRIPTION		DATE		INITIAL		APPROVED	



SECTION D-D

200900 MJS
19-09-28

DART AEROSPACE	
TITLE	PULLER-BEARING AND SEAL RING, FRONT COMPRESSOR
DWG NO.	RB23005023-3
REV	1
DRAWN BY: CLOUGH	
APPROVED: <i>J. Gilbert</i>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
XXX ± .010	FRACTIONS ± 1/8
XX ± .02	ANGLES ± 1°
X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45°	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	1:1
DATE	8/11/2015
SHEET 4 OF 5	

③ RING

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐		Date: _____ Sequence #: _____ Description Work Order Deviation		QTY Affected: _____ Disposition		MRB (QS1042)	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐		Power Loss/Surge ☐ ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ ☐ Weld ☐ ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ ☐		Positioned Wrong ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐					
				Completed By		Lead hand / Supervisor		QC / QA Coordinator			



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER POHB045129



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045129

PO Date: 11/18/19

Due Date: 11/26/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-20

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198991	RBW6510G05431-6F	RBW6510G05431-6F Rev A	Wrench Assembly #2 -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 -Certificate of Conformity is required	Firmed	-	11/26/19	2 pcs	0 pcs	2 pcs	\$4.35/pcs	\$8.70
2	202116	RB T101530-19	RB T101530 Rev A	Base Outside Processing Black Oxide -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/26/19	4 pcs	0 pcs	4 pcs	\$4.55/pcs	\$18.20



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Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	201161	RBT18520-5	RBT18520 Rev Q	Weldment -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/26/19	8 pcs	0 pcs	8 pcs	\$2.25/pcs	\$18.00
4	200301	RBE350A94-3700-B-05	RBE350A94-3700-B Rev 6	Foot Outsource12 (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/26/19	36 pcs	0 pcs	36 pcs	\$1.97/pcs	\$70.92
	200302				Firmed	-	11/27/19	37 pcs	0 pcs	37 pcs	\$1.97/pcs	\$72.89
Sub Total:								73	0	73		\$143.81
5	201162	RBT18520-7	RBT18520 Rev Q	Pivot Bar Weldment -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Steel -Certificate of Conformity is required	Firmed	-	11/26/19	6 pcs	0 pcs	6 pcs	\$4.70/pcs	\$28.20



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PURCHASE ORDER

POHB045129



Items

Line	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	199052	RBW6510G06531-6F-3	RBW6510G06531-6F Rev A	Support #2 -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/26/19	7 pcs	0 pcs	7 pcs	\$14.75/pcs	\$103.25
7	199051	RBW6510G06531-6F-2	RBW6510G06531-6F Rev A	Support #1 -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/26/19	7 pcs	0 pcs	7 pcs	\$14.75/pcs	\$103.25
8	200898	RB23005023-1	RB23005023 Rev 1	Support -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	11/26/19	4 pcs	0 pcs	4 pcs	\$2.95/pcs	\$11.80



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PURCHASE ORDER **POHB045129**



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	200900	RB23005023-3	RB23005023 Rev 1	Ring -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	11/26/19	6 pcs	0 pcs	6 pcs	\$3.15/pcs	\$18.90
Grand Total:												\$454.11

Order Notes

Procurement Quality Clauses
 A005 right of entry
 A012 chemical and physical test report
 A016 personnel qualification
 A017 raw material identification (as applicable)

A022 Apical Processing
 A024 process certifications
 A026 certification of material conformance

A041 quality management system
 A042 dart notification by supplier
 A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Guerin

Plex 11/20/19 9:28 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(024203-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

024203 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-6200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Data expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
22-Nov-2019		Jigar Patel		POHB045129				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/ Scrap/	À venir/ Back Order
8	RBW6510G06531-6F-2 Rev.A	RBW6510G06531-6F OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	7	7	0	0	0
9	RB23005023-1 Rev.1	RB23005023 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0
10	RB23005023-3 Rev.1	RB23005023 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Go Jmy

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.



GROUPE

altech

FM-1020 Rev 20151005

Certificat de Conformité / Certificate of Compliance

(024203-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip

024203 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
22-Nov-2019		Jigar Patel				POHB045129				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)			CATG. U/M	Quantités / Quantities				À venir / Back Order
						Comm. /Ordered	Exp. /Shipped	Qté NC/ NC Qty	Qté Scrap/	
1	RBW6510G05431-6F Rev.A	RBW6510G05431-6F OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS			OXIDE-BLACK CH	2	2	0	0	0
2	RB T101530-19 Rev.A	RB T101530 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS			OXIDE-BLACK CH	4	4	0	0	0
3	RBT18520-5 Rev.Q	RBT18520 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1			BLACK-OXIDE CH	8	8	0	0	0
4	RBE350A94-3700-B-05 Rev.6	RBE350A94-3700-B 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1			OXIDE-BLACK CH	36	36	0	0	0
5	RBE350A94-3700-B-05 Rev.6	RBE350A94-3700-B 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1			OXIDE-BLACK CH	37	37	0	0	0
6	RBT18520-7 Rev.	RBT18520-7 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 WIPE OFF EXCESS			OXIDE-BLACK CH	6	6	0	0	0
7	RBW6510G06531-6F-3 Rev.A	RBW6510G06531-6F OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS			OXIDE-BLACK CH	7	7	0	0	0

RECEIVED

NOV 25-2019

DART AEROSPACE LTD.